

Date: Wednesday, 1/30/2008 7:51:29 AM  
 User: Kim Johnston

## Process Sheet

|                       |  |                  |               |
|-----------------------|--|------------------|---------------|
| Customer              | : CU-DAR001 Dart Helicopters Services        | Drawing Name     | : FLOAT WEB   |
| Job Number            | : 37052                                      |                  |               |
| Estimate Number       | : 10791                                      |                  |               |
| P.O. Number           | :  | Part Number      | : D3282041    |
| This Issue            | : 1/30/2008 S.O. No. :                       | Drawing Number   | : D3282 REV C |
| Prsht Rev.            | : NC   | Project Number   | : N/A         |
| First Issue           | : / /  | Drawing Revision | : C           |
| Previous Run          | : 35211                                      | Material         | :             |
|                       | Type : MACHINED PARTS                        | Due Date         | : 2/5/2008    |
| Written By            | :  | Qty:             | 12 Um: Each   |
| Checked & Approved By | :  |                  |               |
| Comment               | : Est Rev.B 05.09.23 Procedure change KJ/JLM |                  |               |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |          |           |
|-----|----------|-----------|
| 1.0 | D2792130 | EXTRUSION |
|-----|----------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2792-130

Extrusion

33518

Identify as D3282-1

(12)

SL 8-2-19

|     |                |                         |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

SL 8-2-19

|     |       |                                |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 &amp; Dwg D3282

2-Deburr

JF/ML 08/02/23

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF/ML 08/02/23

|     |     |              |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J-F 08/02/24 (12)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 37052

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

J10 8-2-25

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BF 08-02-25

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B 36345

(24)

M 8-2-27

9.0

MS20470AD47

Rivet, Universal Head



(P10)

Comment: Qty.: 57.0000 Each(s)/Unit Total: 684.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M 105940

(690)

M 8-2-27

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web

ARN/ALPS-3 M 104929

8-2-27

(12)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/02/08 (12)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

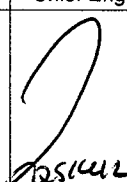

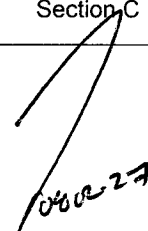

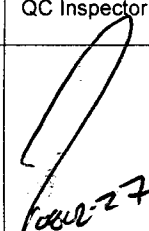
DP

8-3-4

(12)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 08/03/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:    |      | WORK ORDER NON-CONFORMANCE (NCR)  |  |   |   |  |  |  |
|---------|------|---|--|---|---|--|--|--|
| DATE    | STEP | Description of NC<br>Section A  | Corrective Action Section B  |   |   | Verification<br>Section C  | Approval<br>Chief Eng  | Approval<br>QC Inspector   |
|         |      |   | Initial<br>Chief Eng   | Action Description<br>Chief Eng   | Sign &<br>Date  |  |  |  |
| 0802-27 | 9.0  | 1 rivet had to be removed,<br>and the hole became slightly<br>oversized.<br><br>R.C: Human error. |  | Replace rivet, Qty 1<br>with <del>MS204WS-7</del><br>M <u>2655</u><br>MS 20470ADS-7 | <br>8-2-27 | <br>080227 | <br>080227 | <br>080227 |
|         |      |   |  |   |   |  |  |  |
|         |      |   |  |   |   |  |  |  |

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:51:29 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 37052

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/04

Job Completion



2008/3/04

(12)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                               |               |                               |
|-------------------------------|---------------|-------------------------------|
| <b>DART AEROSPACE LTD</b>     |               | <b>Work Order:</b> 37052      |
| <b>Description:</b> Float Web |               | <b>Part Number:</b> D3282-041 |
| <b>Inspection Dwg:</b> D3282  | <b>Rev:</b> C | <b>Page 1 of 1</b>            |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

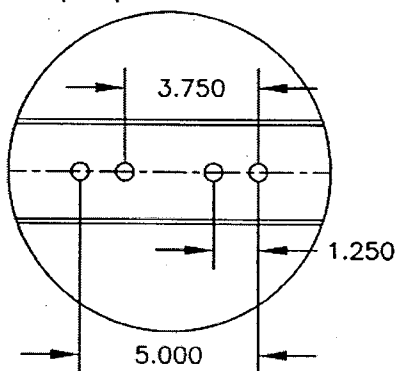
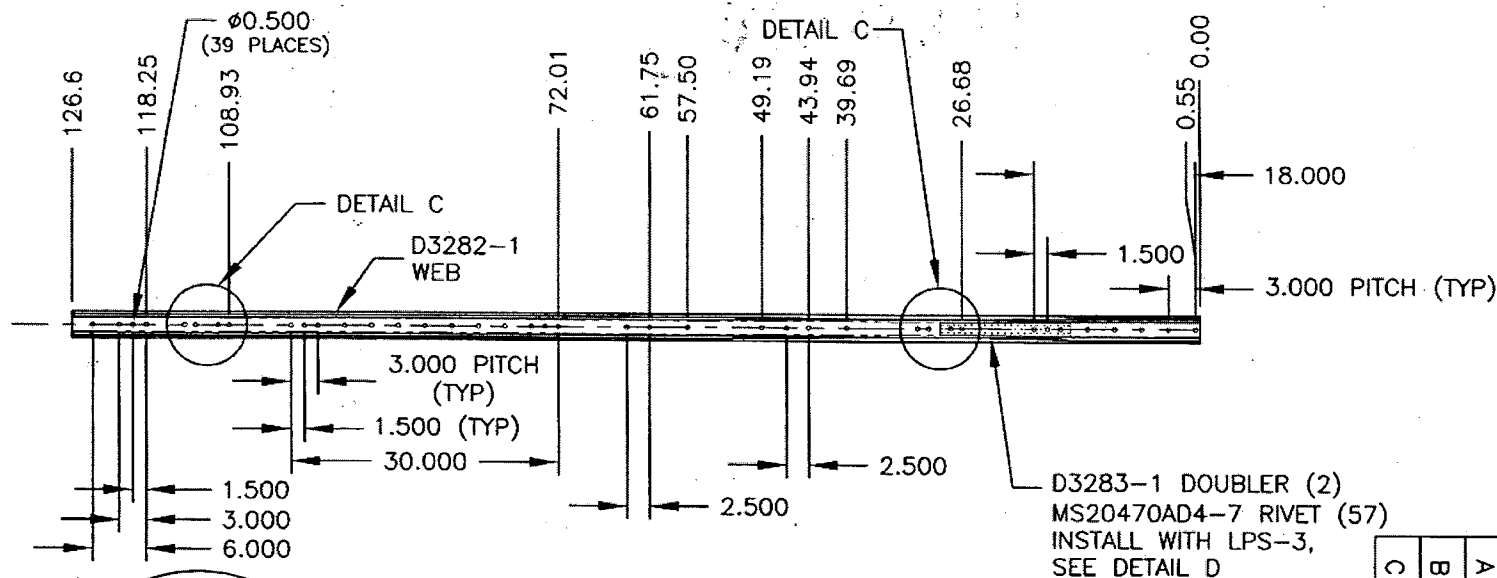
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 126.6             | +/-0.100  | 126.625          | ✓      |        |                      |          |
| 1.500             | +/-0.010  | 1.500            | ✓      |        |                      |          |
| 3.000             | +/-0.010  | 3.000            | ✓      |        |                      |          |
| 6.000             | +/-0.010  | 6.000            | ✓      |        |                      |          |
| 1.250             | +/-0.010  | 1.250            | ✓      |        |                      |          |
| 30.000            | +/-0.010  | 30.000           | ✓      |        |                      |          |
| 1.500             | +/-0.010  | 1.500            | ✓      |        |                      |          |
| 72.01             | +/-0.030  | 72.010           | ✓      |        |                      |          |
| 61.75             | +/-0.030  | 61.750           | ✓      |        |                      |          |
| 57.50             | +/-0.030  | 57.500           | ✓      |        |                      |          |
| 49.19             | +/-0.030  | 49.190           | ✓      |        |                      |          |
| 43.94             | +/-0.030  | 43.940           | ✓      |        |                      |          |
| 39.69             | +/-0.030  | 39.690           | ✓      |        |                      |          |
| 26.68             | +/-0.030  | 26.680           | ✓      |        |                      |          |
| 0.55              | +/-0.030  | 0.550            | ✓      |        |                      |          |
| 1.970             | +/-0.010  | 1.967            | ✓      |        |                      |          |
| 2.38              | +/-0.030  | 2.372            | ✓      |        |                      |          |
| 0.05              | +/-0.030  | 0.060            | ✓      |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |

|                                |                                  |                            |     |
|--------------------------------|----------------------------------|----------------------------|-----|
| <b>Measured by:</b> <i>Amh</i> | <b>Audited by:</b> <i>SA JF-</i> | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 08/02/23          | <b>Date:</b> 08/02/24            | <b>Date:</b>               | N/A |

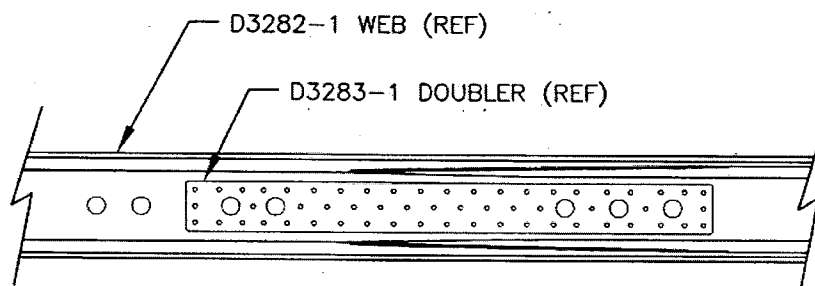
| Rev | Date     | Change    | Revised by | Approved           |
|-----|----------|-----------|------------|--------------------|
| A   | 07.04.02 | New Issue | KJ/JLM     | <i>[Signature]</i> |



|         |                    |                                  |                     |                          |
|---------|--------------------|----------------------------------|---------------------|--------------------------|
| DESIGN  | CP                 | DRAWN BY                         | CP                  | DART AEROSPACE USA, INC. |
| CHECKED | <i>[Signature]</i> | APPROVED                         | <i>[Signature]</i>  | PORT HADLOCK, WA         |
| DATE    | 05.08.09           | DRAWING NO.                      | D3282               | REV. C                   |
|         |                    | TITLE                            | Float Web, 206L/407 | SHEET 1 OF 2             |
|         |                    |                                  |                     | SCALE 1:20               |
| A       | 04.05.05           | NEW ISSUE                        |                     |                          |
| B       | 05.03.16           | MOVE HOLES, ADD D3390-1 DOUBLERS |                     |                          |
| C       | 05.08.09           | REMOVE D3390-1, NOW MACHINED     |                     |                          |



**DETAIL C**  
SCALE 1:5  
RIVET HOLES NOT SHOWN  
FOR CLARITY



**DETAIL D**  
SCALE 1:5

**D3282-041 FLOAT WEB**

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

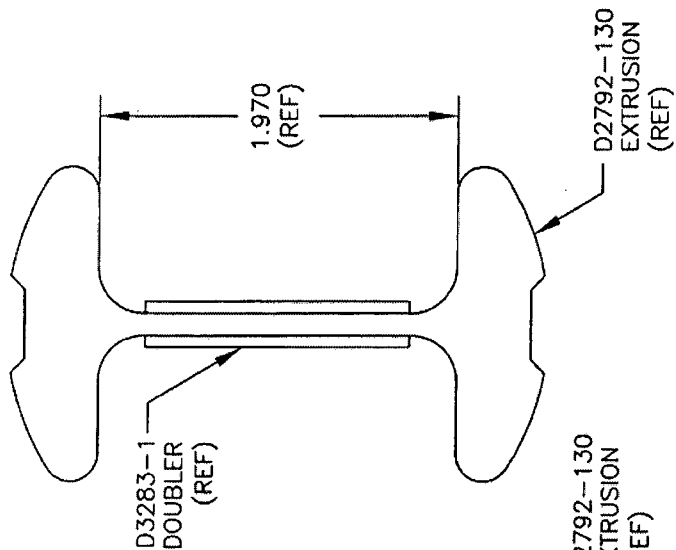
UNCONTROLLED COPY  
SHOP COPY  
RETURN TO  
ENGINEERING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 37852

RELEASED  
05.09.12

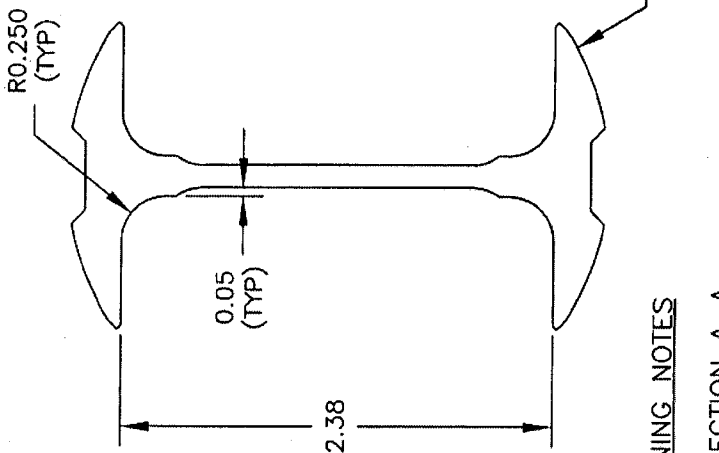


|                        |                         |  |                        |
|------------------------|-------------------------|--|------------------------|
| DESIGN<br>CP           | DRAWN BY<br>CP          | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D3282                         | REV. C<br>SHEET 2 OF 2 |
| DATE<br>05.08.09       |                         | TITLE<br>FLOAT WEB, 206L/407                 | SCALE<br>1:20          |

### SECTION B-B



### SECTION A-A



#### D3282-1 MACHINING NOTES

1 UNIFORM SECTION A-A

2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B

3 UNIFORM SECTION B-B

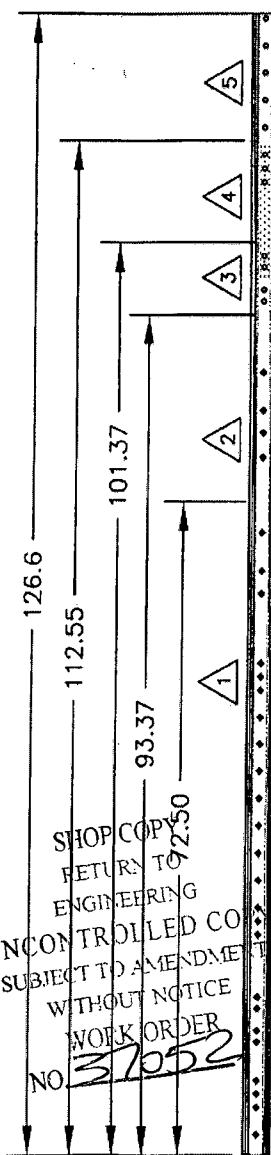
4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A  
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,  
SEE DETAIL D FOR REFERENCE

5 UNIFORM SECTION A-A

6 R1.00 BETWEEN SECTIONS

RELEASED

05-09-12 [Signature]



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